

Work Order ID 55535

January 19, 2010 3:47:25 PM



Page 1

Item ID: D4054-003

Accept



Setup Start



Revision ID:

Item Name: Tube Assembly

Stop



Start Date: 1/19/10 Start Qty: 6.00



Cust Item ID:

Required Date: 1/25/10 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan:

PS

Date: 10-1-19

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4054

A

(6X)

100

0.00



Small Fab

Small Fab

Memo

0.00

Bend tube as per Dwg D4054

with # DT 9576

Install sleeves and nuts

= 7 m. d

10/01/25

Pls ->

Flare ends as per Dwg D4054.

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00





=> Sub 6/25

(x6)

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D4054-003 PAR #: _____ Fault Category: Small P/B NCR: Yes ☒ No ☐ DQA: 1 Date: 10.01.26
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: 55535		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/01/21	100	Scrap 2 length because new Template D3298-003 for new revision D4054-003		Scrap - destroy No replace	JS 10/01/21	S 10/01/25		S 10/01/25
		Rel. Process while while making new templates.						S 10/01/25

NOTE: Date & initial all entries

Work Order ID 55535

January 19, 2010 3:47:25 PM

Page 2

Item ID: D4054-003

Accept

Setup Start

Revision ID:

Stop

Item Name: Tube Assembly

Start Date: 1/19/10 Start Qty: 6.00

Cust Item ID:

Required Date: 1/25/10 Req'd Qty: 6.00

Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

Identify as per dwg & Stock Location: 196

0.00



Packaging

Memo

0.00

Packaging

10-1-26 (6x) SL

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/27 HJ
MF
10-1-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 19, 2010 3:47:29 PM

Page 1

Work Order ID: 55535

Parent Item: D4054-003

Parent Item Name: Tube Assembly

Comments: IPP rev A 10.01.19 new issue EC verified by:DD

Start Date: 1/19/10

Required Date: 1/25/10

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6T0.500W.049		Purchased	No			100	f	128.1400	12.2526			
6061-T6 RD Tube .500 x.049W												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT

128.14

111028

37.53

111944 ✓

90.61

m-l 10/01/21

12.2526

MS20819-8Δ
Sleeve

qty 2

Batch: M112612

(12X)

m-l 10/01/21 *

AN818-8Δ
Nut

qty 2

Batch: M112492

(12X)

m-l 10/01/21 *

M113422

(2X)

m-l 10/01/21 *

AA
10.01.20

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	DT9576
Description: Tube Assembly	Part Number:	D4054-003
Inspection Dwg: D4054-003 Rev: A		Page 1 of 1

☒ **First Article** ☐ **Prototype**

[illegible]

Measured by:	<i>M. H.</i>	Audited by:	<i>S</i>	Prototype Approval:	N/A
Date:	10/01/21	Date:	10/01/21	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM NO.	QTY	P/N	DESCRIPTION
1	X	D4054-001	TUBE ASSEMBLY
2	2	MS20819-8D	SLEEVE
3	2	AN818-8D	NUT

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 55535
D410-1-19

RELEASED
2010-01-14
MD

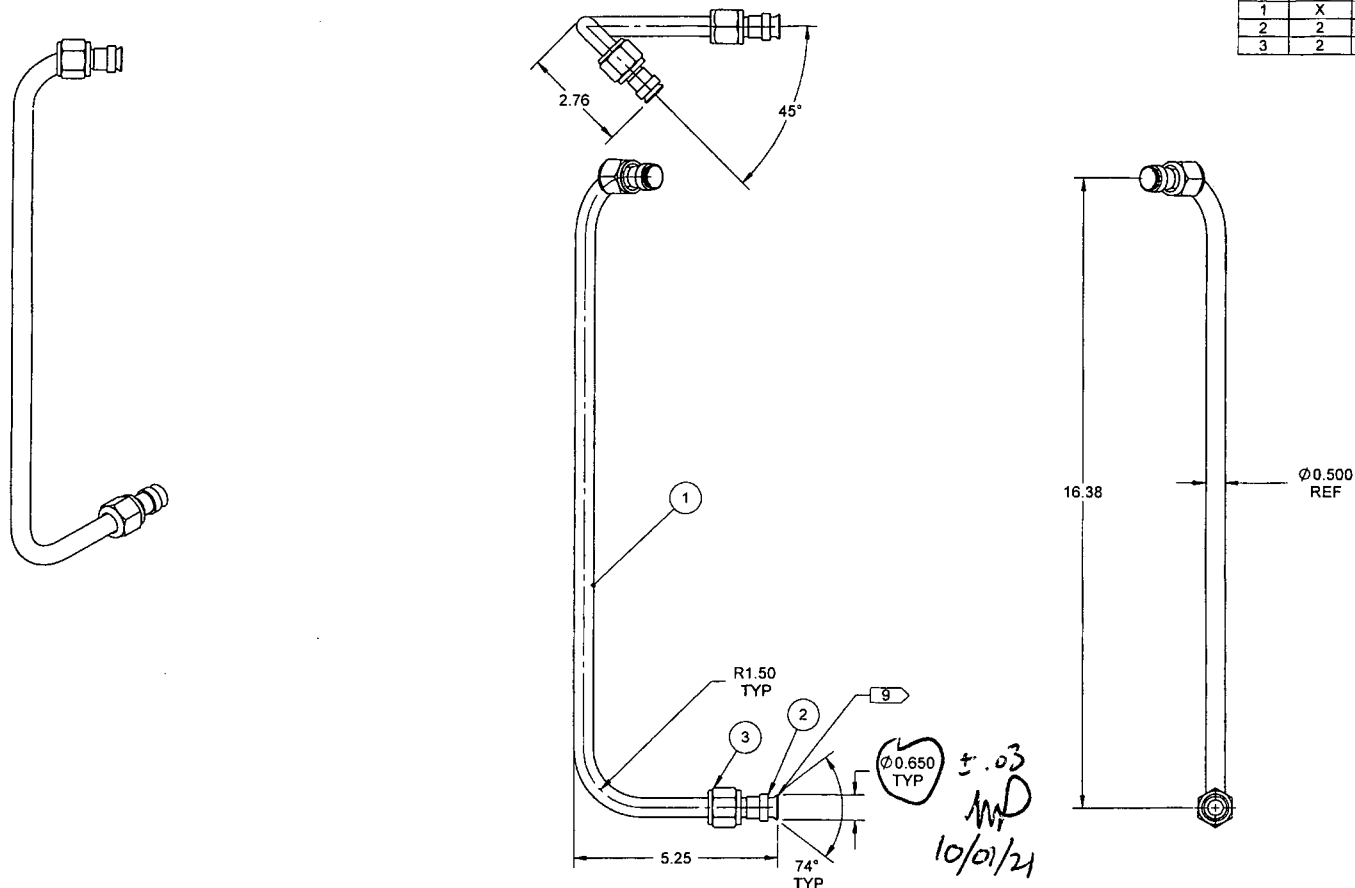
D4054-001 TUBE ASSEMBLY

NOTES:

- 1) MATERIAL: 6061-T6 SEAMLESS ALUMINUM TUBING 0.500 O.D. x 0.049 WALL
PER WW-T-700/6
REF DART SPEC M6061T60.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4054-001" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.20 lbs
- 8) TUBING ASSEMBLIES TO BE CUT AND BENT IN ACCORDANCE WITH TEMPLATE D4054-001T1
- 9) TUBES TO BE FLARED 37° TO MATE WITH MS33514 FITTINGS, TYPICAL
- 10) ENSURE SEAMLESS TUBING IS USED

A	NEW ISSUE	RF	09.12.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>AB</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>EE</i>	D4054	SHEET 1 OF 3
APPROVED	<i>MD</i>	TITLE	SCALE
DE APPR.	<i>AA</i>	TUBE ASSEMBLIES	NTS
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ITEM	QTY -003	P/N	DESCRIPTION
1	X	D4054-003	TUBE ASSEMBLY
2	2	MS20819-8D	SLEEVE
3	2	AN818-8D	NUT



NOTES:

1) MATERIAL: 6061-T6 SEAMLESS ALUMINUM TUBING 0.500 O.D. x 0.049 WALL
PER WW-T-700/6
REF DART SPEC M6061T60.500W.049

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4054-003" USING FINE POINT PERMANENT INK MARKER

7) WEIGHT: 0.21 lbs

8) TUBING ASSEMBLIES TO BE CUT AND BENT IN ACCORDANCE WITH TEMPLATE D4054-003T1

9) TUBES TO BE FLARED 37° TO MATE WITH MS33514 FITTINGS, TYPICAL

10 ENSURE SEAMLESS TUBING IS USED

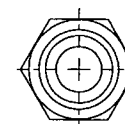
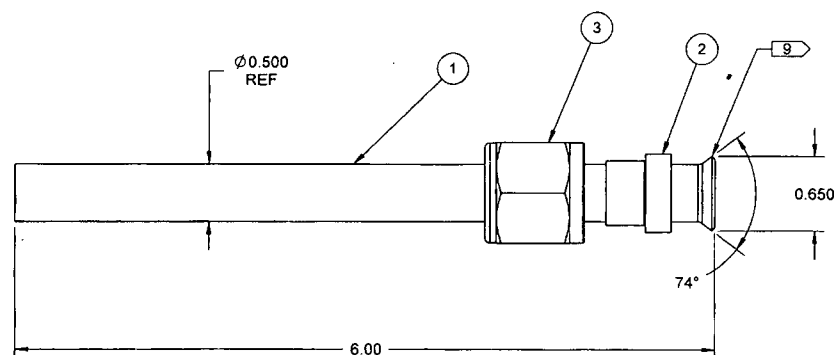
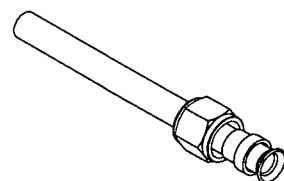
D4054-003 TUBE ASSEMBLY

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RELEASED
2010-01-14
MP

W/O 55535

ITEM	QTY -009	P/N	DESCRIPTION
1	X	D4054-009	TUBE ASSEMBLY
2	1	MS20819-8D	SLEEVE
3	1	AN818-8D	NUT



D4054-009 TUBE ASSEMBLY

NOTES:

- 1) MATERIAL: 6061-T6 SEAMLESS ALUMINUM TUBING 0.500 O.D. x 0.049 WALL
PER WW-T-700/6
REF DART SPEC M6061T60.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4054-009" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.07 lbs
- 8) TUBING ASSEMBLIES TO BE CUT AND BENT IN ACCORDANCE WITH TEMPLATE D4054-009T1
- 9) TUBES TO BE FLARED 37° TO MATE WITH MS33514 FITTINGS
- 10 ENSURE SEAMLESS TUBING IS USED

RELEASED
2010-01-14
WLO

WLO 55535

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CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	RF	D4054	SHEET 3 OF 3
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	TUBE ASSEMBLIES	NTS
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